

5/43  
W/O Split  
DART AEROSPACE LTD

Work Order:

24443A

Description: Aft Tube Assembly

Part Number:

D3391-025

Dwg: D3391 Rev. E

Qty:

2

Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	MA	05.10.24	2
2	MS	Turn as per Folio FA Rev: ____ & Dwg D3391 Rev: <u>C</u> Pick: Qty Part Number Description Batch 1 D6014-090 Extrusion <u>B24315</u> Identify as D3391-3	MA	05/11/08	4
3	QC2	Inspect parts as they come off the machine	MA	05/11/08	4
4	MV	Machine as per Folio FA Rev: <u>C</u> & Dwg D3391 Rev: <u>C</u>	J.L	05.11.12	4
5	QC2	Inspect parts as they come off the machine	MA	05/11/08	4
6	QC8	Second check	MA	05/11/08	4
7	MV	Deburr	J.L	05.11.12	4
8	GB	Form as per Dwg D3391	J.L	05.11.12	4
9	QC5	Inspect work to Step 8	MA	05.11.15	2
10	LG	Drill and c' sink wearshoe holes as per Dwg D3391	MA	05.11.15	2
11	LG	C'sink holes for float bag (4 holes per side) as per Dwg D3391	MA	05.11.15	2
12	LG	Deburr	MA	05.11.15	2
13	QC5	Inspect work to current Step	MA	05.11.15	2
14	FP	Acid etch and Alodine as per QSI 005 4.1	MA	05.11.15	2
15	QC3	Inspect Acid etch and Alodine	MA	05.11.15	2
16	LG	Install inserts and Aft Cap as per Dwg D3391 Pick: Qty Part Number Description Batch 14 AESS10KB366 Insert <u>M17905</u> 8 NAS1330C3KB166 Insert <u>M18308</u> 2 NAS1330C3KB266 Insert <u>M17905</u> 2 NAS1330C3KB316 Insert <u>M17905</u>	MA	05.11.15	2
17	QC5	Inspect work to current Step	MA	05.11.15	2
18	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.1	MA	05.11.15	2
19	QC3	Inspect Powder Coat	MA	05.11.15	2

PRELIMINARY ISSUE



DART AEROSPACE LTD	Work Order:	24443
Description: Aft Tube Assembly	Part Number:	D3391-025
Dwg: D3391 Rev. B	Qty:	2
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Step	Location	Procedure	By	Date	Qty																				
20	LG	Install Aft Cap as per Dwg D3391 <b>Pick:</b> <table border="1"> <thead> <tr> <th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr> </thead> <tbody> <tr> <td>1</td><td>D2646</td><td>Aft Cap</td><td>B23370</td></tr> <tr> <td>2</td><td>AN3C4A</td><td>Bolt</td><td>M17561</td></tr> <tr> <td>2</td><td>AN960C10L</td><td>Washer</td><td>M15822</td></tr> <tr> <td>2</td><td>NAS1515H3L</td><td>Washer</td><td>M17450</td></tr> </tbody> </table> A/R Sikaflex-241/-291 Sikaflex expiry date: _____ Identify as D3391-025	Qty	Part Number	Description	Batch	1	D2646	Aft Cap	B23370	2	AN3C4A	Bolt	M17561	2	AN960C10L	Washer	M15822	2	NAS1515H3L	Washer	M17450		05.11.15	2
Qty	Part Number	Description	Batch																						
1	D2646	Aft Cap	B23370																						
2	AN3C4A	Bolt	M17561																						
2	AN960C10L	Washer	M15822																						
2	NAS1515H3L	Washer	M17450																						
21	QC5	Inspect work to current Step		05.11.15	2																				
22	ST	Identify and Stock	N/A																						
23	AC	Cost / part: 676.65	SAC	05.11.21	2																				
24	DC	Close W/O 676.65 Inspect Level 21		05.11.21	2																				

  

Rev	Date	Change	Revised By	Approved
A	05.09.13	New issue	KJ/EC	

PRELIMINARY ISSUE







# Job Costing Report

Oct 05, 2005  
10:49 am

art Aerospace Ltd.  
awkesbury

ork Order No : 0024443 <sup>A</sup>  
roject Name : D3391-025  
roject For : WK543  
ork Order Type : Main  
ain WO Number :  
ouse Part Number : D3391-025  
Description : Aft Tube Assembly  
Manufactured : Yes  
Amount Req'd : 2  
Amount Done : 0  
Start Date : 10-05-05  
Est Finish Date : 10-28-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
  
Order Entry No :  
OE Value : 0.00  
  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00	0.00	0.00
Engineering Cost :	0.00	0.00	0.00		
Production Hours :	0.00	0.00	0.00	0.00	0.00
Production Cost :	0.00	0.00	0.00		
Packaging Hours :	0.00	0.00	0.00	0.00	0.00
Packaging Cost :	0.00	0.00	0.00		
OverHead Hours :	0.00	0.00	0.00	0.00	0.00
OverHead Cost :	0.00	0.00	0.00		
CNC Hours :	0.00	0.00	0.00	0.00	0.00
CNC :	0.00	0.00	0.00		
Misc. Hours :	0.00	0.00	0.00	0.00	0.00
Misc. :	0.00	0.00	0.00		
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

EROSPACE LTD

Work Order:

244-13

10170 FLOAT SKID TUBE

Part Number:

3341-3

Drawing: D3341

Rev: C

Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.536	±.010	1.530	✓			
12.188	"	12.188	✓			
2.00	"	2.00	✓			
7.500	"	7.495	✓			
36.435	"	36.220	✓			
3.450 + 3.200	"	✓	✓			Taper
88.93	±.03	88.93	✓			
27.750	±.010	27.75	✓			
24.250	"	24.25	✓			
17.250	"	17.250	✓			
1.750	"	1.750	✓			
7.500	"	7.500	✓			
4.208	±.005					
3.300	±.010	3.300	✓			
Ø3.500	"	Ø3.500	✓			
Ø3.000	"	Ø3.000	✓			
.687	±.010	.687	✓			
3.500	±.010	3.500	✓			
2.000	"	2.000	✓			
1.750	"	1.750	✓			
5.250	"	5.250	✓			
Ø.438	±.006	.438	✓			

Measured by: BG

Date: 05/11/14

Audited by: JML

Date: 05/11/14

Prototype Approval:

PH

Date: 05/11/14

Rev: 1

Date:

Change:

New Issue

Revised by:

KJ/RF

Approved:





Date: Friday, 11/18/2005 10:47:54 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT TUBE ASSEMBLY
Job Number : 24443	
Estimate Number : 10699	
P.O. Number :	Part Number : D3391025
This Issue : 11/18/2005 S.O. No. :	Drawing Number : D3391 REV B
Prsht Rev. : NC	Project Number :
First Issue : / / Type : LANDING GEAR	Drawing Revision : B
Previous Run : 24867	Material :
Written By : _____	Due Date : 11/25/2005 Qty: 4 Um: Each
Checked & Approved By : _____	
Comment : Est. 19 QC3 Inspect Powder Coat	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6014090	ALUMINUM EXTRUSION
-----	----------	--------------------

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA Rev: \_\_\_\_ &amp; Dwg D3391 Rev: \_\_\_\_

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Machine as per Folio FA Rev: \_\_\_\_ &amp; Dwg D3391 Rev: \_\_\_\_

Drill aft cap holes per Dwg D3391 using DT8803

Deburr

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

7.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Form as per Dwg D3391

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 10:47:54 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 24443

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Drill and c' sink wearshoe holes as per Dwg D3391

C'sink holes for float bag (4 holes per side) as per Dwg D3391

Deburr

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

12.0

AESS10KB366

Inventory

13.0

AESS10KB166

INSERT

14.0

AESS10KB266

INSERT

15.0

AESS10KB316

INSERT

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts and Aft Cap as per Dwg D3391

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

18.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 10:47:54 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 24443

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

20.0

D2646

Aft Cap

21.0

AN3C4A

Bolt

22.0

AN960C10L

Inventory

23.0

NAS1515H3L

WASHER

24.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Aft Cap as per Dwg D3391

A/R

Sikaflex-241/-291 \_\_\_\_\_

Sikaflex expiry date: \_\_\_\_\_

Identify as D3391-025

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

27.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion





W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 27 Date: 5/11/24  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries